

Patent claims

1. A method for the continuous coating of the inside
of a continuously extruded hollow profile strand of
5 elastic material, in which a hollow profile strand
is guided on a curved, arcuate path through a
supply of a liquid coating agent which remains
stationary in its location, whereby the inner walls
of the hollow profile strand are wetted with
10 coating agent, and in which, directly after running
through the supply of coating agent, the hollow
profile strand is guided upward, rising in its
path, characterized in that excess coating agent is
wiped from one or more inner walls by liquid wipers
15 mounted inside the hollow chambers, by the hollow
profile strand being moved continuously in relation
to the liquid wipers, the liquid wipers, which
comprise at least one magnet or magnetizable
material and at least one wiping lip that touches
20 the inner walls and are arranged in the region of
the rise in the path of the hollow profile
downstream of the supply of coating agent, being
securely held at a constant position within the
path of the hollow profile strand by counter
25 magnets or magnetizable materials, which are fixed
next to the outer side of the continuous hollow
profile strand.
2. The method as claimed in claim 1, characterized in
30 that a liquid wiper which is formed by a body to
which the magnet or magnetizable material and the
wiping lip are fastened is used.
3. The method as claimed in claim 1, characterized in
35 that a liquid wiper which is formed by a magnet or
magnetizable body with a wiping lip is used.

4. The method as claimed in claims 1-3, characterized in that Ni-Fe-B magnets are used as the magnet of the liquid wipers and as counter magnets.
- 5 5. The method as claimed in claims 1-4, characterized in that excess coating agent is wiped off by at least one wiping lip consisting of Teflon, felt and/or silicone.
- 10 6. The method as claimed in claims 1-4, characterized in that excess coating agent is wiped off by at least one wiping lip consisting of expanded Teflon with a density of from 0.3 to 1.8 g/cm³.
- 15 7. The method as claimed in claims 1-6, characterized in that a liquid wiper which comprises not only the wiping lip but also a lip impregnated with coating liquid, which is arranged downstream of the wiping lip in the direction of the path of the hollow
20 profile strand and touches the inner walls of the hollow chamber, is used.
8. The method as claimed in claims 1-7, characterized in that the magnetic or non-magnetic body of the
25 liquid wiper is mounted in the hollow chamber on rotatable rollers fastened to the body.
9. The method as claimed in claims 1-8, characterized in that a hollow profile strand in the form of a
30 sheet with two outer walls and a number of internal webs connecting the outer walls is extruded, each hollow chamber being bounded by two flanges and two webs.
- 35 10. The method as claimed in claim 9, characterized in that two liquid wipers are arranged in each hollow chamber, the first liquid wiper wiping the upper flange and the upper part of the webs and the

second liquid wiper wiping the lower flange and the lower part of the webs and the first liquid wiper being located upstream of the second liquid wiper in the direction of the path of the hollow profile strand.

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11. The method as claimed in claims 1-10, characterized in that a number of layers are applied one after the other.
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12. A liquid wiper (10) for removing liquid coating agent from the chambers of a hollow profile, which can be used for carrying out the method as claimed in claims 1-10, comprising a body (1), magnets or magnetizable materials (2), at least one wiping lip (4), at least one felt lip (5) and rollers (6).
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13. A device for continuously removing liquid coating agent from the chambers of a hollow profile, comprising an extrusion device, guiding rollers (21-29) for a continuously extruded hollow profile strand (8), a supply of coating agent (9), liquid wipers (10a, 10b) as claimed in claim 10 and counter magnets or magnetizable materials (11) which are fastened to holding devices (12).
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